

Shp Jan 9

Page 1

Item ID: D4101-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Bracket

Stop *NS2*

Start Date: 12/18/14 **Start Qty:** 15.00

15

Cust Item ID:**Required Date:** 12/22/14 **Req'd Qty:** 15.00

15

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

[illegible]

December-22-14 10:53:01 AM

128010

Page 3

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

15

Cust Item ID:

15

Customer:

Reference:

Run Start *NR1*

Stop ***NR2***

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

160

Identify as per dwg & Stock Location: *GA*

0.00

160

Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

Picklist Print

December-22-14 10:46:07 AM

Page 1

Work Order ID: 128010

128010

Parent Item: D4101-1

D4101-1

Parent Item Name: Bracket

Start Date: 12/18/14

Required Date: 12/22/14

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP REV:A NEW ISSUE 10-07-11 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X04.50 0		Purchased	No			100	f	1.3000	0.416	6.568421			
										DAS			
										44			
										9-89		15/01/04	
										**			

M6061T6B2 000X04 500

6061T6 Bar 2.00 x 4.500

Location

Loc Qty

Loc Code

MAT004

1.3

M121282

1.3

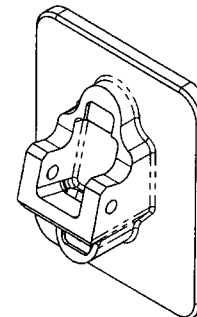
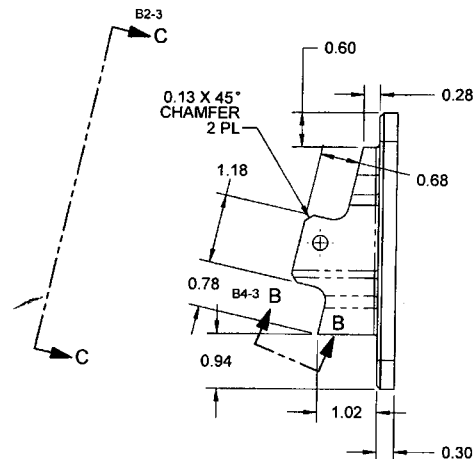
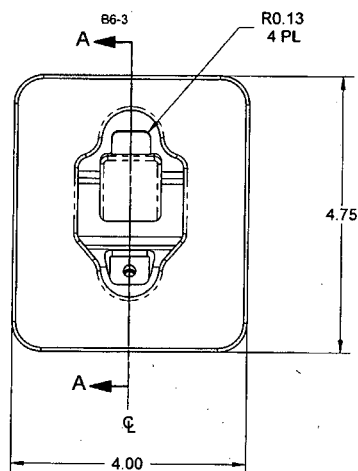
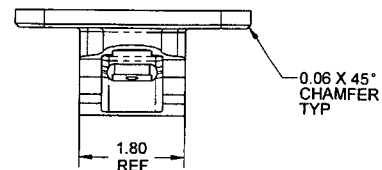
1.3'

M6061T6B 2.000 x 5.000 → 128980
126160

1.66'

3.33'

Could not pull mat!!



D4101-1 BRACKET

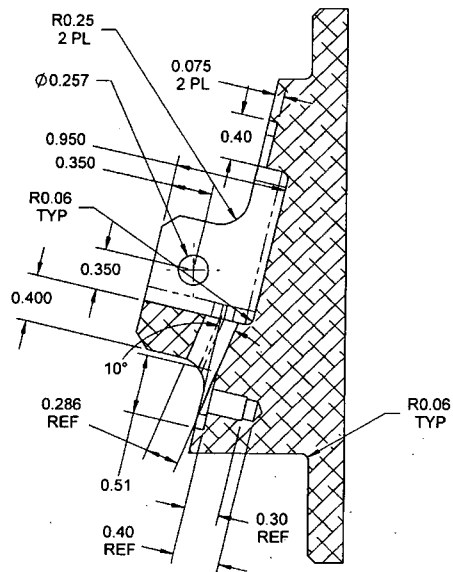
NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.85 lbs

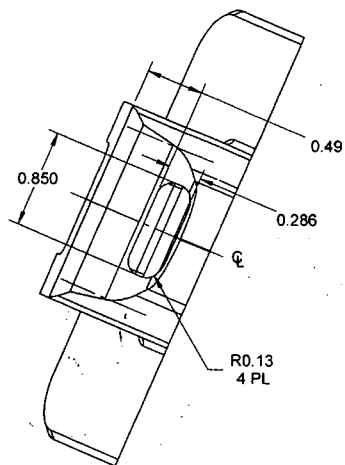
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4101	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 5	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	PRE-FLIGHT STEP ASSEMBLY	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2010-08-23

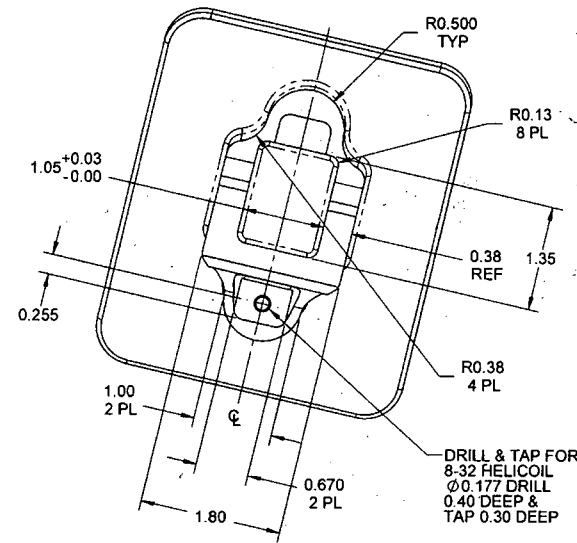
10128000



SECTION A-A C7-2
SCALE 2X



VIEW B-B C4-2
SCALE 2X



VIEW C-C D4-2
SCALE X1.5

RELEASED
2010-08-23

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4101	REV. B SHEET 3 OF 5
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	PRE-FLIGHT STEP ASSEMBLY	NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.08.05		

DART AEROSPACE LTD		Work Order:	128010
Description: Pre-Flight step Assembly		Part Number:	D4101-1
Inspection Dwg: D4101 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.06 x 45°	+/- .030 / + .5°	.055 x 45°	/		Vern	Ft-04
1.80	+/- .030	1.801	/		↑	↓
4.75	+/- .030	4.75	/			
4.00	+/- .030	4.00	/			R-G
R.13	+/- .030	.13	/			
.60	+/- .030	.60	/			
.28	+/- .030	.28	/			
.68	+/- .030	.68	/			
.13 x 45°	+/- .030 / + .5°	.125	/			
1.18	+/- .030	1.18	/			
.78	+/- .030	.78	/			
.94	+/- .030	.94	/			
1.02	+/- .030	1.02	/			
.30	+/- .030	.299	/			↓
R.25	+/- .030	.25	/			R-G
R.06	+/- .030	.06	/			R-G
R.06	+/- .030	.06	/			R-G
.075	+/- .010	.076	/			
.40	+/- .030	.40	/			
Ø.257	+/- .006 / - .001	.259	/			
.950	+/- .010	.952	/			
.350	+/- .010	.350	/			
.350	+/- .010	.350	/			

DAS

Measured by:	44 9-89	Audited by:	Da 08 9-89	Preliminary Approval:	
Date:	15/01/04	Date:	15/01/06	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

DART AEROSPACE LTD		Work Order: 128610
Description: Pre-Flight Step Assembly		Part Number: D4101-1
Inspection Dwg: D4101 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.400	+/- .010	.400	/		Vern	FK-04
.286 REF	+/- .010	.285	/			
.51	+/- .030	.51	/			
.40	+/- .030	.414	/			
.30	+/- .030	.30	/			
.850	+/- .010	.849	/			
.49	+/- .030	.49	/			
.286	+/- .010	.285	/			
R.13	+/- .030	.13	/		R-G.	
R.500	+/- .030	.500	/		"	
R.38	+/- .030	.38	/		"	
R.13	+/- .030	.13	/		"	
1.05	+ .030 / - .000	1.051	/		Vern	FK-04
.255	+/- .010	.255	/			
1.35	+/- .030	.635	/			
.38 REF	+/- .030	.376	/			
1.00	+/- .030	1.00	/			
1.80	+/- .030	1.801	/			
.670	+/- .010	.632	/			

DAS

Measured by: 44 9-89	Audited by: J.A. DAS 08 9-89	Preliminary Approval:
Date: 15/01/04	Date: 15/01/06	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15